Work Order ID 58507



Page 1

May 7, 2010 3:05:47 PM

Item ID:

D3942-1

Accept

Setup Start



Revision ID:

Item Name:

Angle

Stop

Start Date: Required Date: 24/05/2010

07/05/2010

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Process Plan: _

Date: 15-10 Tooling:

Date:

Start Run



Approvals:

QC:_

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Operation Description Set Up/ **Run Hours** Draw Number - Rev.

Plan Draw Code

Accept Qty

Reject Qty

13 10-5-13

Reject Number

Insp. Stamp

Work Center ID Draw Nbr

Revision Nbr

100

Waterjet

FLOW CNC Waterjet

304,000

Memo

1-Cut as per Dwg D3942-1

Dwg Rev:

Prog Rev:

OC2- Inspect parts off machine FAI/FAIB

0.00

2-Deburr if necessary

0.00

SB (dos/14



1B10-5-13

110

Memo

0.00

0.00

Quality Control

Work	Ord	er ID	58507
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Page 2

May 7, 2010 3:05:47 PM

Required Date: 24/05/2010

Item ID:

D3942-1

Accept

Setup Start



Stop

Start Date:

Revision ID:

Item Name:

07/05/2010

Angle

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

QC:

Date:

Tooling:

0.00

Date:

Start



Approvals:

Process Plan:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation **Description**

QC8- Inspect parts - second check

Memo

Set Up/ Run Hours Draw Number

Plan Draw Rev. Code

Accept Qty ianto

Reject Qty

Run

Reject Number

Insp. Stamp

Diolos/14

130

Brake NC

Brake NC

Memo 1- Bend as per dwg D3942 0.00

0.00

80 60/09/17

140

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

Dart Ae	rospace	e Ltd							t .
W/O:				V	VORK ORDER CHANGES				. •
DATE	STEP		PROC	EDURE CI	HANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	: <u>D3</u>	3942-	PAR #:	Fault Ca	ntegory: Smoll Pole No	CR (Yes)	No DQA:		100574
	R	esolutio	1: Scrap	Disposi	tion: <u>Scrap</u> , Q	A: N/C Cld	sed:	Date: <u>/</u>	0/05/18
NCR:58	3507		W	ORK OR	DER NON-CONFORMANC	E (NCR)		
DATE	STEP		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DAIL	JILF		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		Found	at inspection that	1	- 0 0 \ D - h - 11 - c			1	
10/5/14	廿	ary.	of parts to Are		- 500 AT 1 00, 17 aly x5	N,			
	120	cut m	of inspection that is part of short.	SIME	NO REPLACE CHY NO PERINC CHY NEED TO PARK	OF JEN	works	bsun.	World
			V						

Work Order ID 58507

Page 3

May 7, 2010 3:05:47 PM

Item ID:

D3942-1

Angle

Accept

Setup Start



Stop

Revision ID: Item Name:

Start Date:

Required Date: 24/05/2010

07/05/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Start Run



OC:

Date:

SPC (Y/N):

Date:

Draw

Stop



Sequence ID/ **Work Center ID**

150



Packaging ,

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Plan Qty Rev. Code

Accept Reject Qty

Reject Insp. Number Stamp

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Ae	rospace Ltd							,
W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PR	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
Part No.		DAD #-	Fault Oata		NOT Y			
Partino				gory:				
	Resolut	tio i :	Disposition	1:	QA: N/C CI	osed:	Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NCF	₹)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approvat Chief Eng	Approva QC Inspecte
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C		

May 7, 2010 3:05:50 PM

Work Order ID: 58507

Parent Item: D3942-1

Parent Item Name: Angle

Comments:



Start Date: 07/05/2010

112885

Required Date: 24/05/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	141.1179	0.015	18	1210-6	- 13

304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT20	141.1179	
108156	1.7	
111743	10.1	
112885	33.3179	
113062	96	



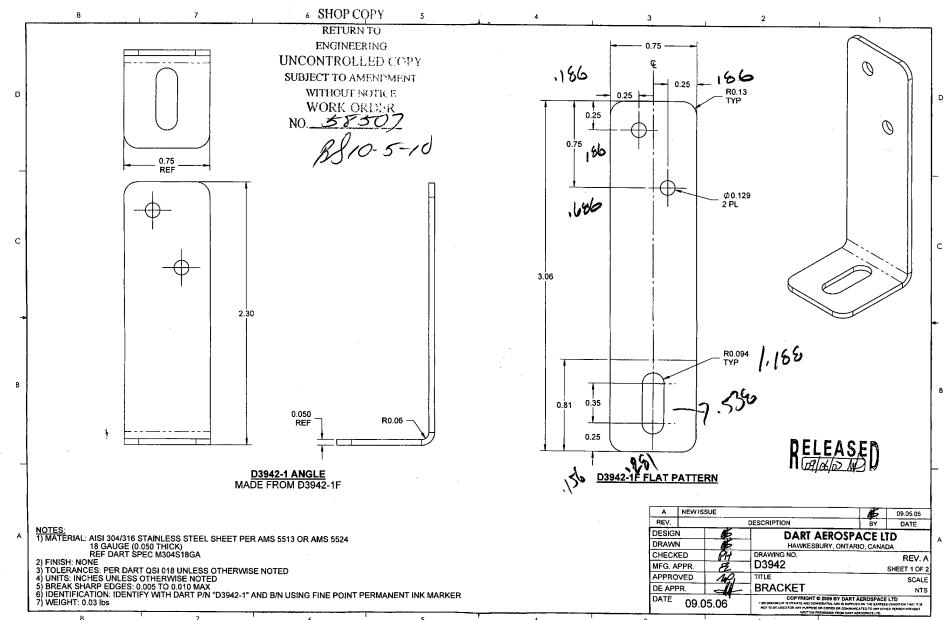
Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Chief Eng / **Approval** DATE **STEP PROCEDURE CHANGE** By Date Qty QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ___ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B Description of NC Verification **Approval** DATE **STEP** Approval **Action Description** Initial Sign & Section A Séction C QC Inspector Chief Eng Chief Eng Date Chief Eng

DART AEROSPACE LTD	Work Order:	58501	
Description: Angle	Part Number:	D3942-1	
Inspection Dwg: D3942 Rev: A		Page 1 of 1	

	FIRST	ARTICLE IN	SPECIIC	JN CHE	CKLIST		
	X	First Artic	ele	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
3.06	+/-0.030	3,070	5				
0.75	+/-0.030	.156	'				
Ø0.129	+0.005/-0.001	,131	8				
0.75	+/-0.030	749	4				
0.25	+/-0.030	.256	dy				
0.25	+/-0.030	.250	¥				
0.25	+/-0.030	.350	×				
0.35	+/-0.030	350	W				
						_	
					·		
							•
				1			
Measured by:	B	Audited by:	8		Prototype Ap		N/A
Date:	10-5-13	Date:	10/05/	14		Date:	N/A
Rev Date A 09.06.22	Change New Issue			/	Revise KJ	d by	Approved
A 09.06.22	14CW 133UC						

Dart Aerospace L	.td
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:		Date:		
				sition: QA: N/C Closed:						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip Chief Eng Chief Eng		Section B tion Sign & Date		on	Approval Chief Eng	Approval QC Inspector	
			Office Ling	Office Ling	Date					
:										
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									<u> </u>	



Dart Ae	rospace	e Ltd							,	
W/O:				WO	RK ORDER CHANG	iES				
DATE	STEP		PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
						NCR: Yes No DQA: Date: _				
	Resolution:			Disposition	_ QA: N/C Clo	sed:	Date: _			
NCR:			,	WORK ORDE	R NON-CONFORM	ANCE (NCR)				
DATE	STEP		Description of NC		····	ion B	Verification	Approval	Approval Approval	
DAIL	SIEF	Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto	
		į								
			1							
									-	
NOTE: D	ate & initi	al all entri	es					<u> </u>	L	

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

 \bigcirc D 0 - 0.75 0.25 0.25 0.25 0.75 С Ø0.129 2 PL 2.00 w/0 58507 Ø0.257 -0.31 - 0.38 0.050 REF D3942-3 CLIP

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-3" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.02 lbs

8

DESIGN	4	□ DART AEROS	SPACE LTD		
DRAWN	₩	HAWKESBURY, ON			
CHECKED	PH	DRAWING NO.	REV. A		
MFG. APPR.	臣	D3942	SHEET 2 OF 2		
APPROVED	140	TITLE	SCALE		
DE APPR.	#	BRACKET	NTS		
DATE 09.0	5.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTROL ON AND IS SUPPLIED ON THE EXPRESS CONDITION WOTTO BE USED FOR MAY PAIRPOSE OR COPIED ON COMMUNICATION ON MY OTHER PERSON WITHIN SERVICEMENT ON THE ARCHITECTURE OF THE ARC			

Dart Ae	rospace Ltd									
W/O:			WC	RK ORDER CHANG	ES	Y 41.				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approva QC Inspect		
Part No:		PAR #:	Fault Cateo	jory:	NCR: Yes No DQA: Date:					
	Resolutio :		Disposition:		_ QA: N/C C	losed:	Date: _			
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCF	₹)				
DATE		Description of NC		Corrective Action Section		Verification	Approval	Approva QC Inspecto		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng			
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